

EVO[®] EM "37 SERIES"

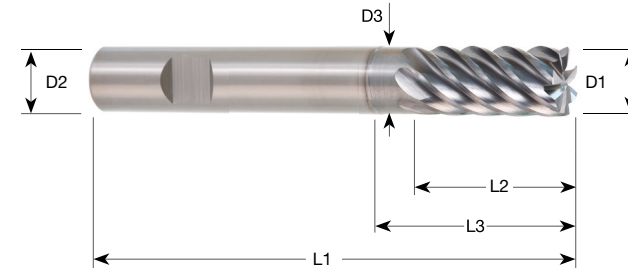


| Solid Carbide End Trochoidal Mills
| Frese Trocoidali in Metallo Duro

... THE WAY TO THE FUTURE!



A 3D diagram of a stepped block. The block has a tall left section and a shorter right section. A force vector, represented by an arrow, is applied to the vertical face of the tall section, pointing downwards and slightly to the left.



P 2.3
 $\leq 1300 \text{ N/mm}^2$

M 2.1
Aust.

S 2.2

Inconel 625

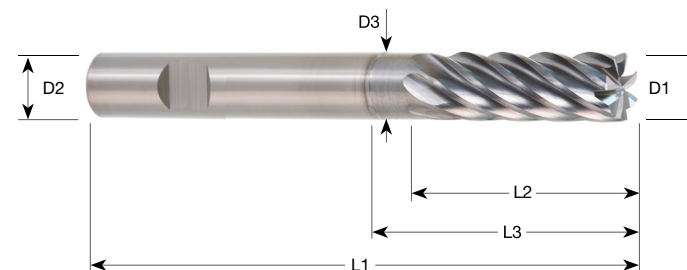
K 1.2
Ghisa

H 1.1
≤ 48 HRC

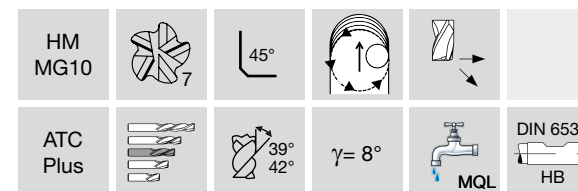
HM MG10					
ATC Plus					

[illegible]

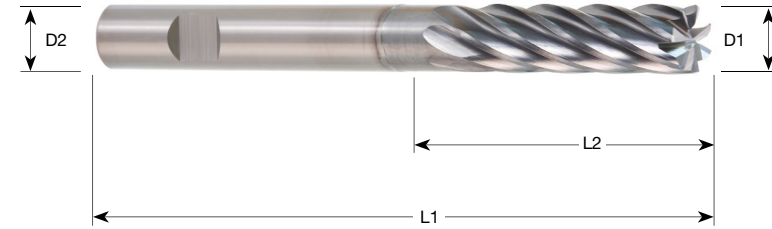
TROCHO EM 3739L



H 1.1
≤ 48 HRC

[illegible]

A 3D diagram of a stepped block. A force vector F is applied to the vertical face of the highest step, pointing downwards and to the left. The block has three steps of decreasing height from left to right.



HM MG10					
ATC Plus			$\gamma = 8^\circ$		DIN 6350 HB

P 2.3
 $\leq 1300 \text{ N/mm}^2$

M 2.1
Aust.

S 2.2

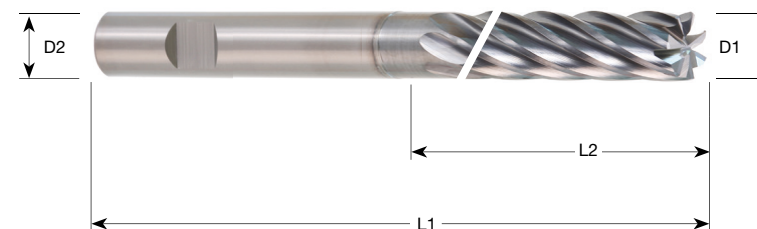
Inconel 625

K 1.2
Ghisa

H 1.1
≤ 48 HRC

[illegible]

mat.	ø mm	Z	Vt m/min	fz mm	ap mm	ae mm	n rpm	Vf mm/min	Q cm³/min
P 1.1	8	7	200	0,140	40	0,45	7962	7803	140,4
Construction steel Acciaio da costruzione	10	7	200	0,180	50	0,60	6369	8025	240,8
	12	7	200	0,200	60	0,80	5308	7431	356,7
	16	7	200	0,280	80	0,90	3981	7803	561,8
	20	7	200	0,350	100	1,00	3185	7803	780,3
≤ 850 N/mm²									
P 2.2	8	7	160	0,100	40	0,45	6369	4459	80,3
Heat treatable steel Acciaio da bonifica	10	7	160	0,130	50	0,60	5096	4637	139,1
	12	7	160	0,160	60	0,80	4246	4756	228,3
	16	7	160	0,200	80	0,90	3185	4459	321,0
	20	7	160	0,250	100	1,00	2548	4459	445,9
≤ 1100 N/mm²									
P 4.2	8	7	120	0,090	40	0,45	44777	3010	54,2
Cold work tool steel Acciaio da utensili per lavorazioni a freddo	10	7	120	0,110	50	0,60	3822	2943	88,3
	12	7	120	0,130	60	0,80	3185	2898	139,1
	16	7	120	0,180	80	0,90	2389	3010	216,7
	20	7	120	0,220	100	1,00	1911	2943	294,3
12% Cr									
M 2.1	8	7	100	0,040	40	0,45	3981	1115	20,1
Stainless steel Acciaio inossidabile	10	7	100	0,050	50	0,60	3185	1115	33,4
	12	7	100	0,070	60	0,80	2654	1300	62,4
	16	7	100	0,090	80	0,90	1990	1254	90,3
	20	7	100	0,100	100	1,00	1592	1115	111,5
Aust.									
S 1.2	8	7	50	0,050	40	0,45	1990	697	12,5
Titanium alloys Leghe di Titanio	10	7	50	0,070	50	0,60	1592	780	23,4
	12	7	50	0,090	60	0,80	1327	836	40,1
	16	7	50	0,110	80	0,90	995	766	55,2
	20	7	50	0,150	100	1,00	796	836	83,6
Ti Gr.3/Ti Gr.4									
S 2.2	8	7	30	0,030	40	0,45	1194	251	4,5
Inconel 625	10	7	30	0,040	50	0,60	955	268	8,0
	12	7	30	0,050	60	0,80	796	279	13,4
	16	7	30	0,070	80	0,90	597	293	21,1
	20	7	30	0,090	100	1,00	478	301	30,1
H 1.1	8	7	100	0,060	40	0,45	3981	1672	30,1
Hardened Steel Acciaio Temprato	10	7	100	0,080	50	0,60	3185	1783	53,5
	12	7	100	0,100	60	0,80	2654	1858	89,2
	16	7	100	0,120	80	0,90	1990	1672	120,4
	20	7	100	0,160	100	1,00	1592	1783	178,3
≤ 48 HRC									



P 2.3
 $\leq 1300 \text{ N/mm}^2$

M 2.1
Aust.

S 2.2

Inconel 625

K 1.2
Ghisa

H 1.1
≤ 48 HRC

HM MG10					
ATC Plus			$\gamma = 8^\circ$		DIN 650 HB

[illegible]



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